

Date: Friday, 28/11/2008 3:05:23 PM  
User: Julie Dawson

## **Process Sheet**

|  |  |  |                  |                |  |
|--|--|--|------------------|----------------|--|
| Customer   | : CU-DAR001 Dart Helicopters Services  |  | Drawing Name     | : STEP SPACER  |  |
| Job Number   | : 43858D   |  |                  |                |  |
| Estimate Number  | : 10380  |  |                  |                |  |
| P.O. Number  | :  |  | Part Number      | : D30657       |  |
| This Issue   | : 28/11/2008   | S.O. No. :   | Drawing Number   | : D3065 REV. B |  |
| Prsht Rev.   | : NC   |  | Project Number   | : N/A          |  |
| First Issue  | : / /  | Type : SMALL /MED FAB  | Drawing Revision | : B            |  |
| Previous Run   | : 42344D   |  | Material         | :              |  |
| Written By   | :  |  | Due Date         | : 20/12/2008   |  |
| Checked & Approved By  | : <u>JO 08/12/01</u>   |  | Qty:             |                |  |
| Comment  | : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF<br>Est Rev:D Now on Water Jet 06-04-11 JLM |  |                  |                |  |
| <b>Additional Product</b>  |  |  |                  |                |  |
| Job Number:  |           |  |                  |                |  |
| <b>Seq. #:</b>   | <b>Machine Or Operation:</b>   | <b>Description :</b>   |                  |                |  |
| 1.0  | M2024T3S040  | 2024-T3 .040 sheet   |                  |                |  |
|  |           | <br><i>HB 8-12-19</i>   |                  |                |  |
| Comment: Qty.: 0.1653 sf(s)/Unit Total : 8.2635 sf(s)<br>Material: 2024-T3 (QQ-A-250/4) 0.040" thick<br>(M2024T3S.040) Batch: <u>i07 461 x 40</u><br><u>i07 572 x 20</u> |  |  |                  |                |  |
| 2.0  | WATER JET  | FLOW WATER JET   |                  |                |  |
|  |         |                       |                  |                |  |
| Comment: FLOW WATER JET<br>1-Cut as per Dwg D3065<br>Dwg Rev: <u>B</u> Prog Rev: <u>B</u> <i>HB 8-12-19</i>  |  |  |                  |                |  |
|  | <i>HB 8-12-19</i>  |                       |                  |                |  |
| 3.0  | QC2  | INSPECT PARTS AS THEY COME OFF MACHINE   |                  |                |  |
|  |         | <br><i>HB 8-12-19</i> |                  |                |  |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE  |  |  |                  |                |  |
| 4.0  | QC8  | SECOND CHECK   |                  |                |  |
|  |         | <br><i>S 8/12/19</i>  |                  |                |  |
| Comment: SECOND CHECK  |  |  |                  |                |  |
| 5.0  | SMALL FAB 1  | SMALL & MEDIUM FAB RESOURCE 1  |                  |                |  |
|  |         | <br><i>S 8/12/19</i>  |                  |                |  |
| Comment: SMALL & MEDIUM FAB RESOURCE 1   |  |  |                  |                |  |
| Deburr if necessary.   |  |  |                  |                |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Friday, 28/11/2008 3:05:23 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 43858D

Part Number: D30657

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

*E/08/12/22*

*DR 08/12/22*

*59*

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Jes-12-23*

*Counted &  
Stacked by 10's.*

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



*AWM 9-1-06*

*59*

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*SS*

*09/01/07*

*X59*

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Sylvie GA*

*SS*

*09/01/07*

*X59*

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*SS*

*09/01/07*

*X59*

Job Completion



*WBL.DL.07*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                          |              |             |
|--------------------------|--------------|-------------|
| DART AEROSPACE LTD       | Work Order:  | H3858P      |
| Description: Step Spacer | Part Number: | D3065-7     |
| Inspection Dwg: D3065    | Rev: B       | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

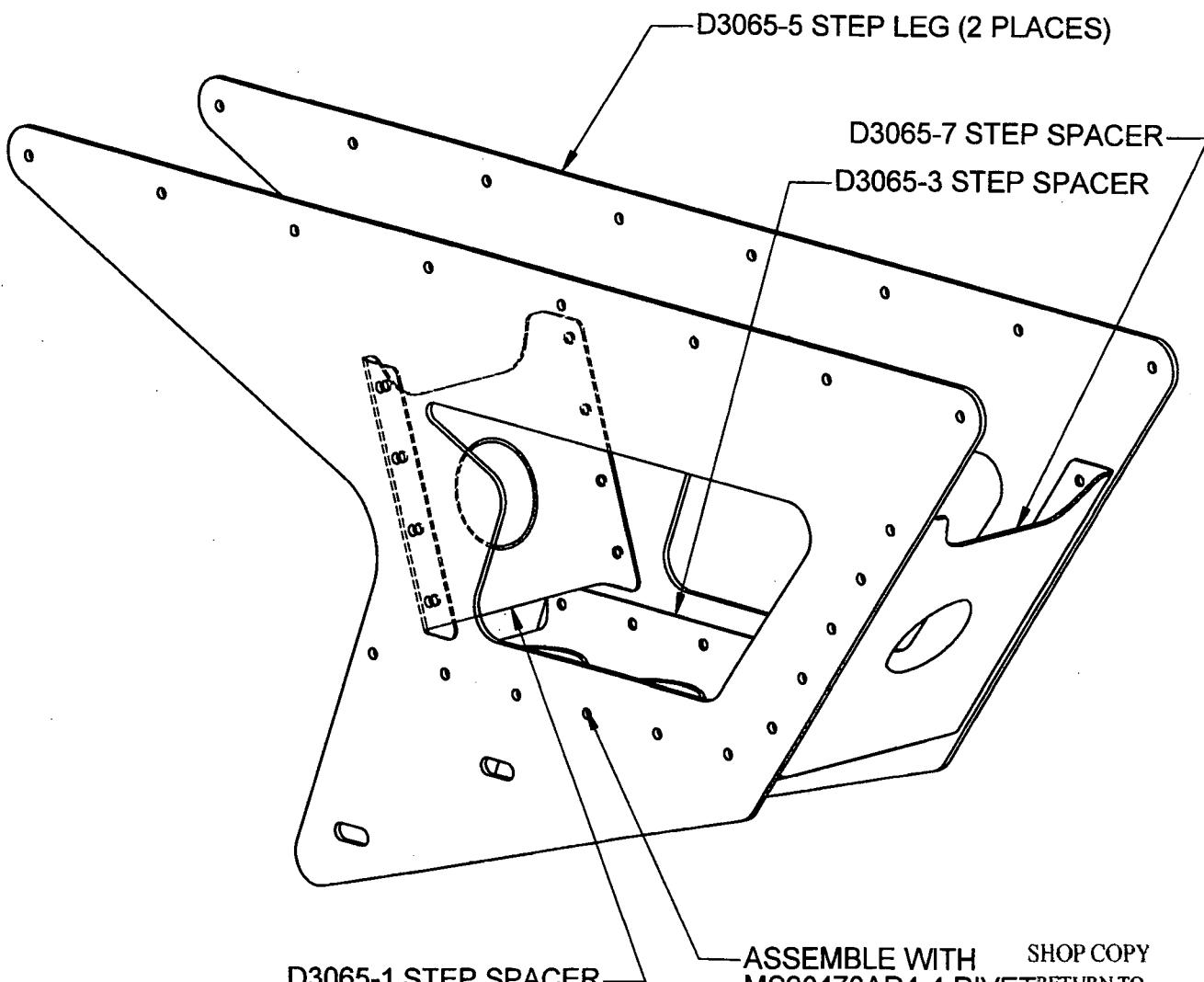
## X First Article      Prototype

|              |          |             |          |                     |     |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | FB       | Audited by: |          | Prototype Approval: | N/A |
| Date:        | 08-17-19 | Date:       | 08/12/19 | Date:               | N/A |

| <b>Rev</b> | <b>Date</b> | <b>Change</b>                                       | <b>Revised by</b> | <b>Approved</b> |
|------------|-------------|---|-------------------|-----------------|
| A          | 03.09.22    | New Issue P/O D3065-041                             | KJ/RF             |                 |
| B          | 04.05.15    | Removed 0.531, 3.686, 0.580; Added 3.936 dimensions | KJ/JLM            |                 |
| C          | 06.06.23    | Dwg Rev. changed                                    | KJ/JLM            |                 |

**DART**

|                         |                       |  |                        |
|-------------------------|-----------------------|--|------------------------|
| DESIGN<br><i>CP</i>     | DRAWN BY<br><i>CB</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i>    | APPROVED<br><i>MM</i> | DRAWING NO.<br><b>D3065</b>                              | REV. B<br>SHEET 1 OF 5 |
| DATE<br><b>06.05.23</b> |                       | TITLE<br><b>STEP LEG ASSEMBLY</b>                        | SCALE<br>1:2           |
| A                       | 02.09.11              | NEW ISSUE  |                        |
| B                       | 06.05.23              | ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5               |                        |

**RELEASED***06.06.20 MM***D3065-1 STEP SPACER**

ASSEMBLE WITH **MS20470AD4-4 RIVET** SHOP COPY  
(30 PLACES) RETURN TO ENGINEERING

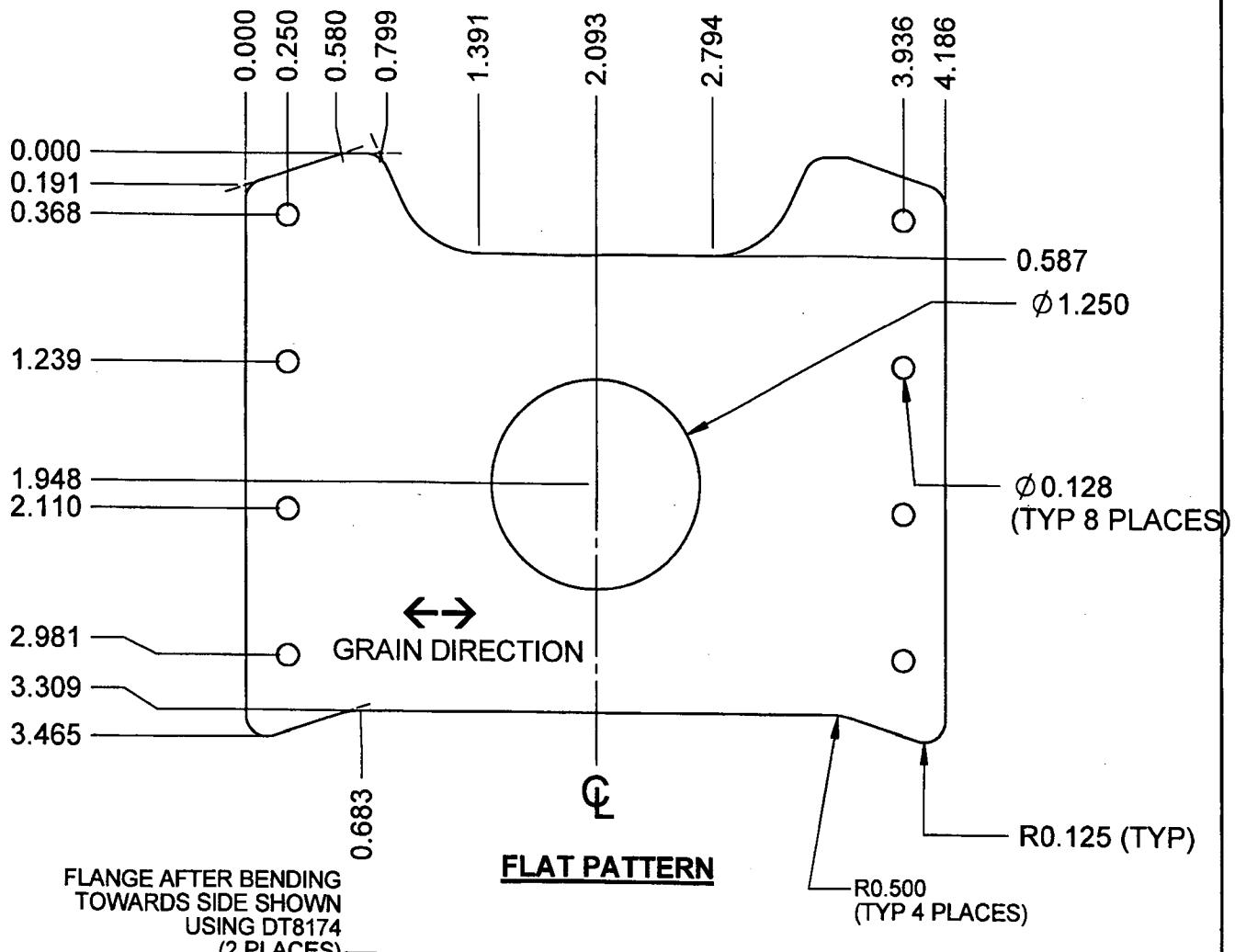
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| CHECKED<br><i>PH</i> | APPROVED<br><i>M</i>  | DRAWING NO.<br>D3065                              | REV. B<br>SHEET 2 OF 5 |
| DATE<br>06.05.23     |                       | TITLE<br>STEP LEG ASSEMBLY                        | SCALE<br>1:1           |

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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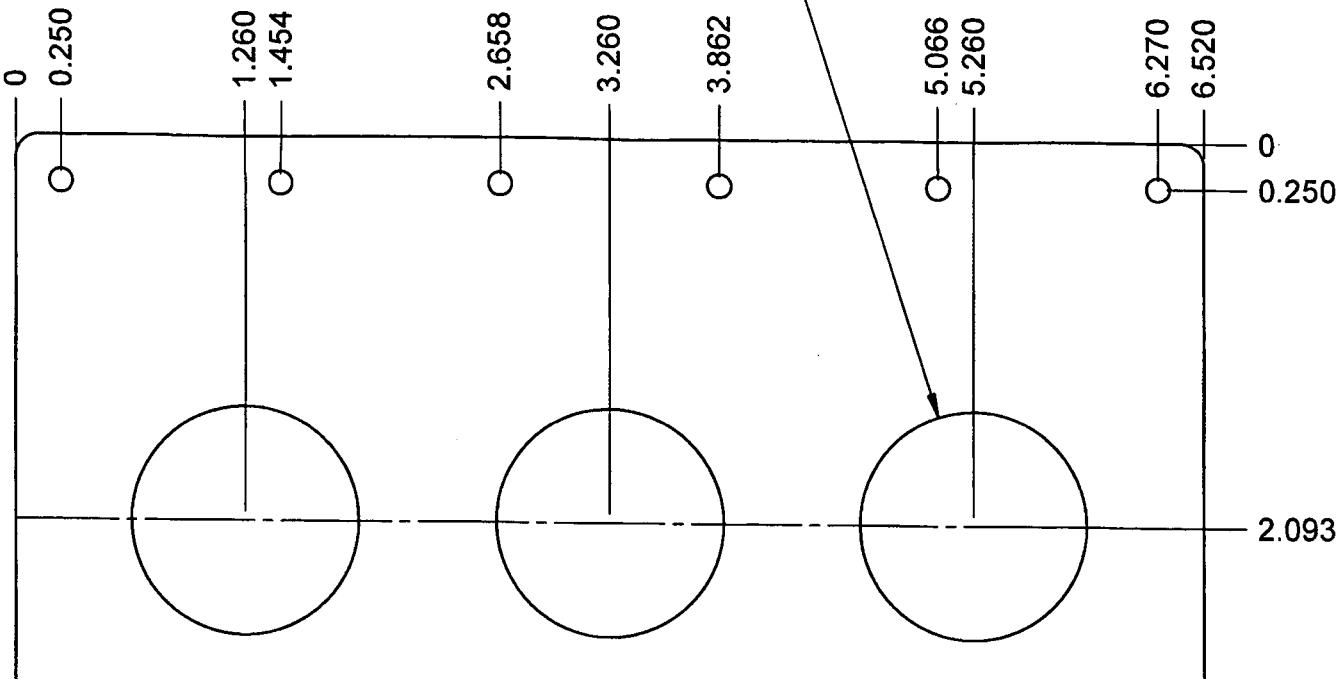
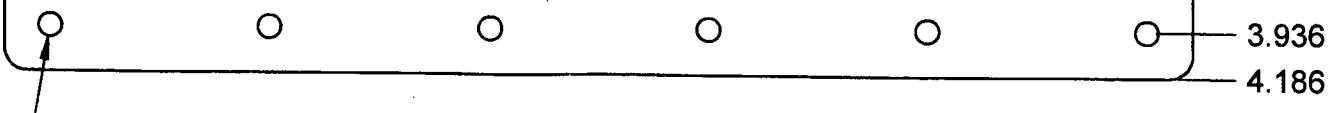
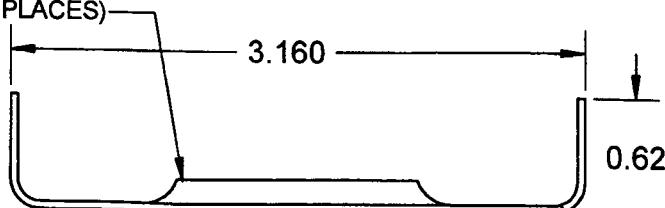
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| CHECKED<br><i>PH</i> | APPROVED<br><i>MM</i>      | DRAWING NO.<br>D3065                                     | REV. B<br>SHEET 3 OF 5 |
| DATE<br>06.05.23     | TITLE<br>STEP LEG ASSEMBLY | SCALE<br>1:1   |                        |

 $\phi 1.250$  (TYP, 3 PLACES)FLAT PATTERN  
GRAIN DIRECTION $\phi 0.129$  (TYP, 12 PLACES)**RELEASED***06.05.20 - MM***BEND DETAIL**

R0.125  
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**D3065-3 STEP SPACER**

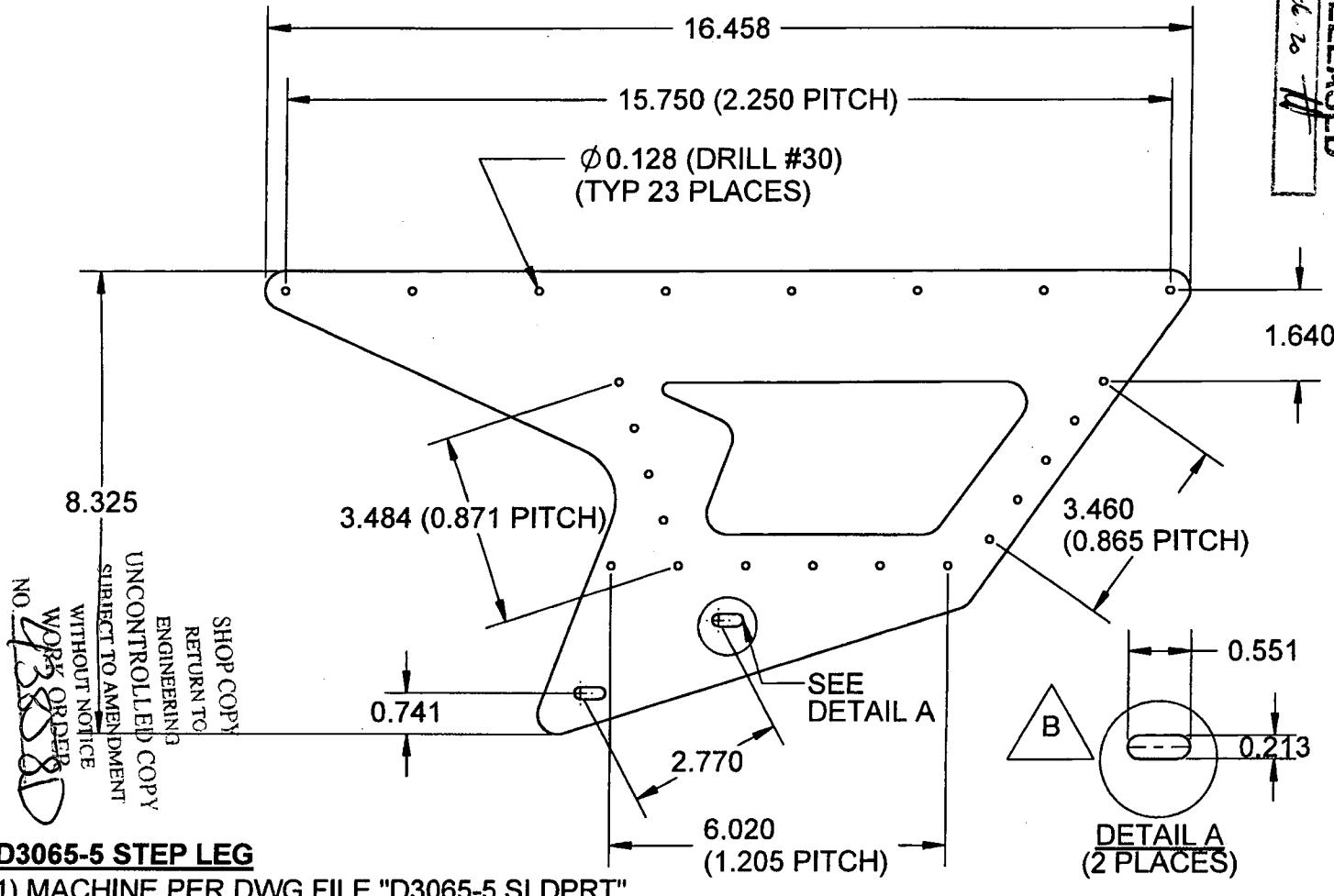
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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**DART**

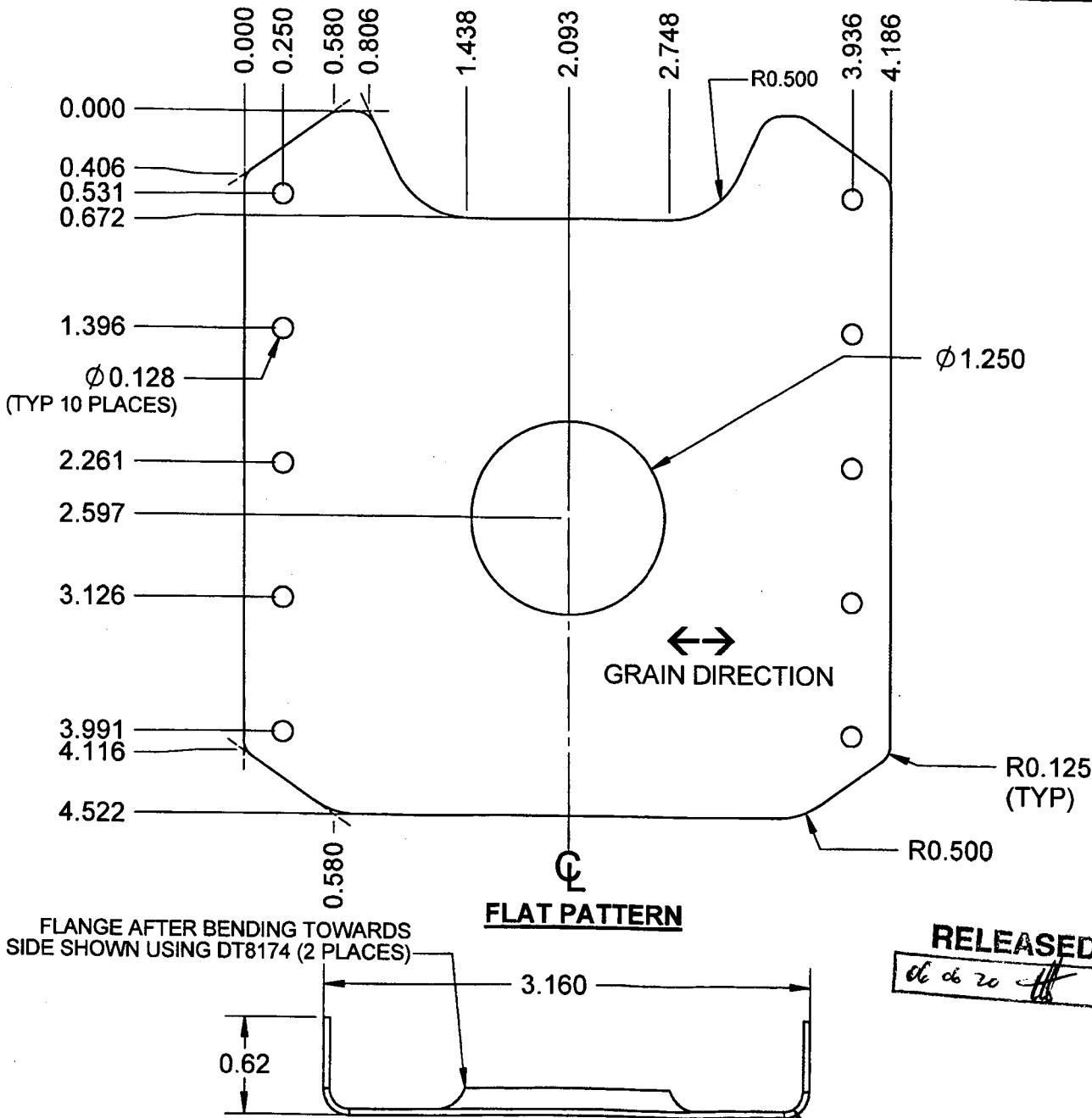
|                      |                            |   |
|----------------------|----------------------------|---|
| DESIGN<br><i>CP</i>  | DRAWN BY<br>C.B.           | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>PH</i> | APPROVED<br><i>JW</i>      | DRAWING NO.<br>D3065                              |
| DATE<br>06.05.23     | TITLE<br>STEP LEG ASSEMBLY | REV. B<br>SHEET 4 OF 5<br>SCALE<br>1:3            |

**RELEASED**  
06.06.20 *H***D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

**DART**

|                      |                            |   |                        |
|----------------------|----------------------------|---|------------------------|
| DESIGN<br><i>CP</i>  | DRAWN BY<br><i>CB</i>      | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i> | APPROVED<br><i>MM</i>      | DRAWING NO.<br>D3065                              | REV. B<br>SHEET 5 OF 5 |
| DATE<br>06.05.23     | TITLE<br>STEP LEG ASSEMBLY | SCALE<br>1:1                                      |                        |

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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